

303 . 750

Work Order ID 115700

115700

Page 1

April-04-14 10:17:01 AM

Item ID: D3403-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bushing

Start Date: 4/04/14

Start Qty: 24.00

24

Cust Item ID:

Required Date: 4/04/14

Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 14-04-08

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3403	D

100 Hardinge CNC LATHE SMALL 0.00 24 0 DAS 14-05-13
100 Hardinge Memo 0.00 20 9-89

Hardinge CNC Lathe Small 1- Turn as per Folio FA556 & Dwg D3403
 Folio Rev: A Dwg Rev: D
 2-Deburr

110 QC2- Inspect parts off machine FAI/FAIB 0.00 24 0 DAS 14-05-13
110 QC Memo 0.00 20 9-89

Quality Control

120 QC8- Inspect parts - second check 0.00 24 0 DAS 14-05-13
120 QC Memo 0.00 40 9-89

Quality Control

1

Date: _____



WORK ORDER NON-COMPLIANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order Update Form				Work Order Update Summary					
Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No.				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No.				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>	
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
				Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>		
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
FAULT CATEGORY									
Landing Gear	General								
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced					
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up					
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure					
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld					
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled					
Crushing	Countersink	Misaligned/off center	Positioned Wrong						
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge						
Inspection Strip in Tube	Drawing	Misread							
Marks/Chatter	Drill Holes	Off-set							
Turning Sequence	Finish	Out of Calibration							
Wave/Twist in Tube	Fit/Function	Out of Sequence							

Work Order ID 115700

April-04-14 10:17:01 AM

115700

Page 2

Item ID: D3403-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bushing

Stop

NS2

Start Date: 4/04/14

Start Qty: 24.00

24

Cust Item ID:

Required Date: 4/04/14

Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

130

Identify as per dwg & Stock Location:

8641

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

130

Packaging

Packaging

0.00

24 X 145-13

DAS
26
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

MJ 14-05-03

AD 14-05-03

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
				Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
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Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function				<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence			
								<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge			
								<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled			
								<input type="checkbox"/> Other			

Picklist Print

April-04-14 10:17:01 AM

Page 1

Work Order ID: 115700

115700
D3403-1

Parent Item: D3403-1

Parent Item Name: Bushing

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A05.08.31New issueKJ/JLM
IPP Rev:B 06-03-07 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	52.6450	0.217	6			

M303R0 750

303 Round Bar 0.750

** 5.521 DAS 20 14-05-13
9-89

Location	Loc Qty	Loc Code
MAT028	52.645	
m127464	52.645	

u128882

5.521

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

OA Closed:

Date:

Work Order update only

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
				Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
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Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>							
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>							
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>							
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>							
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>							
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>								
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>								
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>									
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>									
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>									
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>									

DART AEROSPACE LTD	Work Order:	115700
Description: Bushing	Part Number:	D3403-1
Inspection Dwg: D3403	Rev: D	Page 1 of 1

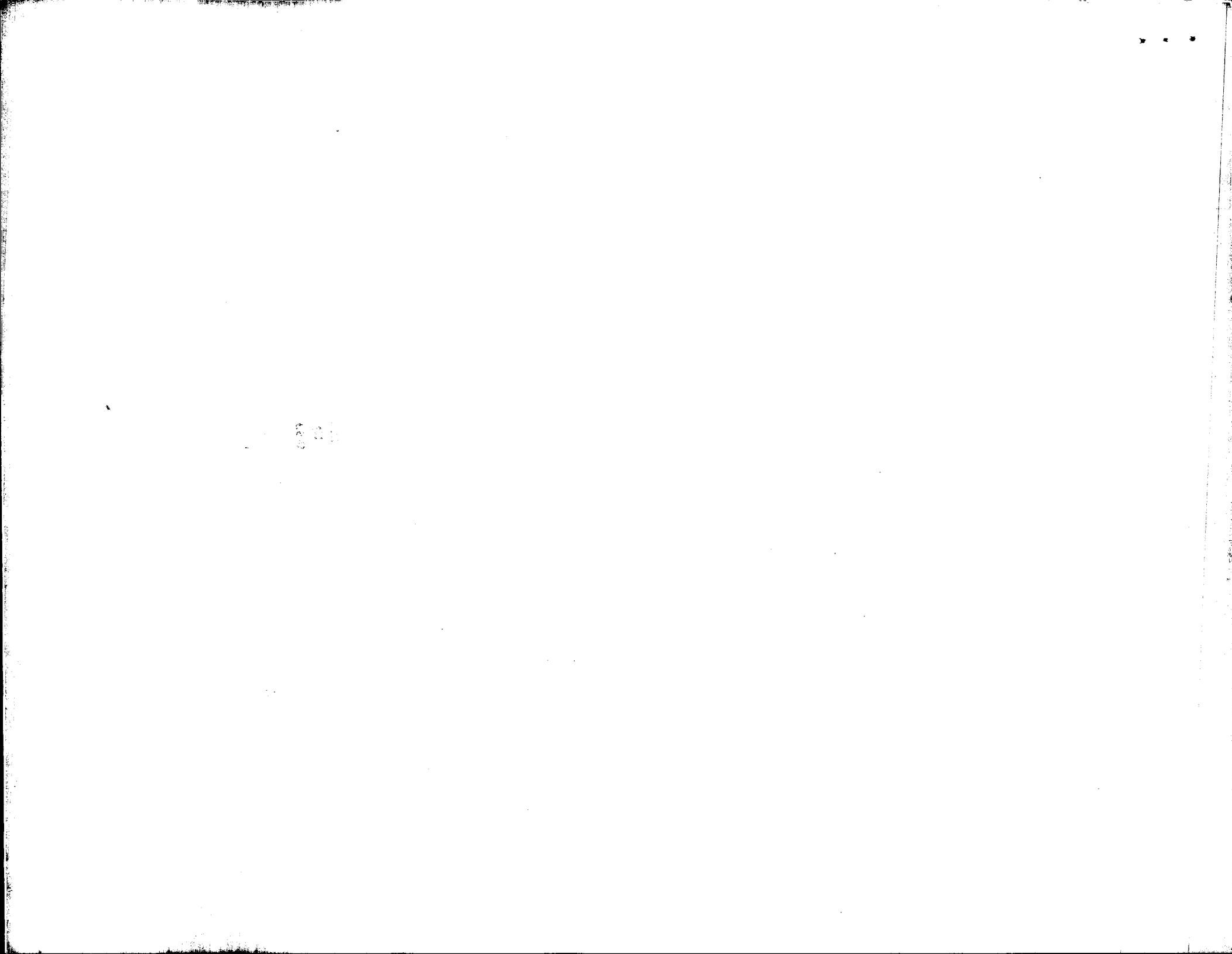
FIRST ARTICLE INSPECTION CHECKLIST

BAS

49

Measured by:	<i>SJ</i>	Audited by:	40 9-89	Preliminary Approval:	
Date:	14/05/13	Date:	14/05/13	Date:	

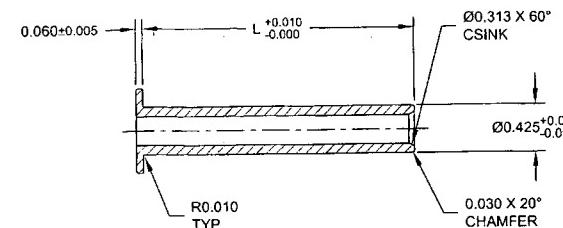
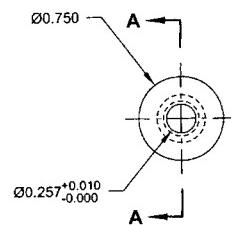
Rev	Date	Change	Revised by	Approved
A	06.04.21	New Issue	KJ/JLM	
B	10.11.17	Dimensions updated per Dwg Rev C	KJ	
C	12.07.31	Dwg Rev updated	KJ	jj



8 7 6 5 4 3 2 1

D

D



SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 115700 MLJ

14-04-08

14-04-08

SECTION A-A

D3403-X BUSHING

DART P/N	L	WEIGHT (lbs)
D3403-1	2.416	0.07
D3403-3	2.165	0.06
D3403-5	2.440	0.07



RELEASED
2011-10-31
W

D	FOR -5, 2.440 WAS 2.500 (PER PAR 11-125)	XDF	11.10.28
C	REFORMAT TO CURRENT STD PER QSI 043; ADDED D3403-5. TOL WAS +0.005/-0.000. REASON: PAR#10-029	MB	10.04.21
B	ADD COUNTERSINK	PH	06.01.23
A	NEW ISSUE	PH	05.03.07
REV.	DESCRIPTION	BY	DATE
	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	XDF		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3403	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BUSHING	NTS
DATE	11.10.28	COPRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR
PER ASTM A582
REF. DART SPEC. M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

8 7 6 5 4 3 2 1

A

11

